

Date: Monday, 6/12/2006 3:25:36 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CAP
Job Number	: 27488	Part Number	: D2855
Estimate Number	: 10519	Drawing Number	: D2855 REV. A
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 6/12/2006 S.O. No. : N/A	Drawing Revision	: A
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 6/30/2006
Previous Run	: 26351	Qty:	25 Um: Each
Written By	: <u>[Signature]</u>		
Checked & Approved By	: <u>[Signature]</u> 06.06.13		
Comment	: Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC		

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 1490

Cast per Dwg D2855

Material Release Note Required

C 206115/06 (25) 100

2.0 D2855P Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 25.0000 Each(s)  
CAP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- Drill as per Dwg D2855 using DT8235

2- Open holes to 19/64"

3- Deburr

SB 06/06/23 99

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 27488

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*06-08-23*

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*GREEN*  
Powder Coat White-Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*FLY 06/11/14 x 4*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*a.m 06/11/14 (4)*

9.0

ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 50.0000 Each(s)

INSERT

Pick:

Qty Part Number Description  
2 ALS7-1032-225 Insert  
or AKS7-1032-225  
or ALS4-1032-225  
or AKS4-1032-225

Batch  
*M19393*

*a.m 06/11/14 (4)*

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

*a.m 06/11/14 (4)*

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*FL 06/11/14 (4)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *F05*

*FL 06/11/14 (4)*



## Process Sheet

Customer: CU-DAR001 Part Helicopters Services

Drawing Name: CAP

Job Number: 27488

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

SD 06/11/15

Job Completion



U 06 11-15

CERTIFICAT DE CONFORMITÉ  
CERTIFICATE OF COMPLIANCEFONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD714-716 CALAIS, DORVAL, QC H9P-2P3  
TEL : (514) 831-1331 FAX: (514) 831-8448Expédié à  
Shipped

DART AEROSPACE

A.F. &amp; P.W.Série no./Serial no.

1270 Aberdeen Street

Packing  
Date: 14/08/2006 Slip No. 6111

Hawksbury, ON, K6A 1K7

Vôtre No. Commande 1490  
Your order No.

Ceci est pour certifié que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats de détaillants sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Spécifications	Note d'autorisation Incoming Release note
100	DRWG D 2855 rev A	Z098046	A356.2	B#0619301 Ingot #815076

Analyse  
Analysis (as in Ingot)

(Si)	7.00%	(Al)	balance
(Fe)	0.08%		
(Cu)	<0.01%		
(Mn)	<0.01%		
(Mg)	0.44%		
(Zn)	<0.01%		
(Ti)	0.16%		

Donne  
Yield :Résistance à la tension :  
Tensile Strength :Allongement par pouce carré :  
P.S.I. Elongation :

%

Pour et au nom de  
For and on behalf of :FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTDDept/Dep :  
Par/Per :

Coc-100